



Date: Thursday, 10/08/2006 10:01:45 AM
 User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TUBE ASSEMBLY |
| Job Number : 28130 | |
| Estimate Number : 11489 | |
| P.O. Number : N/A | Part Number : D2003027 |
| This Issue : 10/08/2006 S.O. No. : N/A | Drawing Number : D2003 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 25270 | Material : N/A |
| Written By :  | Due Date : 05/09/2006 Qty: 5 Um: Each |
| Checked & Approved By :  | |
| Comment : Est Rev: A 05.12.15 New Issue AP | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0500W035 | 6061-T6 Tube .500 x.035W |
|-----|------------------|--------------------------|



Comment: Qty.: 0.6999 f(s)/Unit Total : 3.4997 f(s)
 Material: 6061-T6 tubing Ø 0.500" x 0.035" wall
 (M6061T6T0.500W.035)
 Batch: 174692

FF 06.08.14 5

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



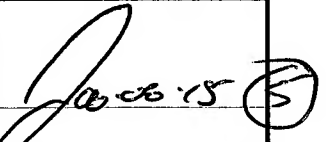
Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form tube as per template D2003-027

FF 06.08.14 5

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP



| | | |
|-----|--------|--------------------------|
| 4.0 | M26506 | Firesleeve-crkl .375IDia |
|-----|--------|--------------------------|



Comment: Qty.: 0.6343 f(s)/Unit Total : 3.1715 f(s)
 Firesleeve-crkl .500IDia
 Qty Part Number Description Batch
 1 M2650-6 Heat Sleeve M17521

FF 06.08.15 5

| | | |
|-----|-----------|--------|
| 5.0 | MS208198D | Sleeve |
|-----|-----------|--------|



Comment: Qty.: 2.1000 Each(s)/Unit Total : 10.5000 Each(s)
 Pick:

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/08/17
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 28130

Part Number: D2003027

Job Number:



Seq. #:

Machine Or Operation:

Description :

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | MS20819-8D | Sleeve | M19099 |

FF 06.08.15

5

6.0

AN8188D

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | AN818-8D | Nut | M19413 |

FF 06.08.15

5

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Cut tube 7.38" long as per Dwg D2003
Cut Heat sleeve 7.25" long as per Dwg D2003.
Install Red decal and heat shrink
Assemble as per Dwg D2003

B21864A

FF 06.08.15

5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/08/16

5

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST03

AB 06/08/16

5

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/08/17

5

Job Completion



u 06/08/17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------|----------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2003 | REV. B SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 99.06.08 | | 206 CABIN HEATER TUBE ASSEMBLIES | NTS |
| A | 90.04.09 | NEW ISSUE | |
| B | 99.06.08 | UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049) | |

RELEASED
99.06.08 KE

| P/N | TEMPLATE | HEATSLEEVE LENGTH ¹ | CUT LENGTH OF TUBE ² | MS20819-8J SLEEVE | AN818-8J NUT | MS20819-8D SLEEVE | AN818-8D NUT | MS20819-6D SLEEVE | AN818-6D NUT | DESC. | MATERIAL ^{4/8/7} | VENDOR OR SPEC |
|-----------|-----------|-----------------------------------|------------------------------------|-------------------|--------------|-------------------|--------------|-------------------|--------------|------------|----------------------------|-------------------|
| D2003-001 | T2003-001 | 5.2 | 6.00 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-003 | T2003-003 | 7.3 | 8.12 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-005 | T2003-005 | 9.8 | 10.62 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-007 | T2003-007 | 20.0 | 19.63 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-009 | T2003-009 | 12.38 | 12.44 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-011 | T2003-011 | 33.31 | 32.38 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-013 | T2003-013 | 12.7 | 13.54 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-015 | T2003-015 | 17.2 | 18.00 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-017 | T2003-017 | 17.0 | 16.25 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-019 | T2003-019 | 9.8 | 10.62 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-021 | T2003-021 | N/A | 2.25 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-023 | T2003-023 | 4.5 | 5.33 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-025 | T2003-025 | 9.8 | 10.60 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-027 | T2003-027 | 7.25 | 7.38 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-029 | T2003-029 | 17.2 | 18.00 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-700/6 |
| D2003-031 | T2003-031 | 14.6 | 15.38 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-033 | T2003-033 | 29.75 | 29.62 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-035 | T2003-035 | 24.7 | 27.00 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-037 | T2003-037 | 24.81 | 23.38 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-039 | T2003-039 | 34.0 | 34.00 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-041 | T2003-041 | 6.0 | 5.88 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-043 | T2003-043 | 11.7 | 10.75 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-045 | T2003-045 | 3.50 | 2.44 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-047 | T2003-047 | 5.56 | 5.56 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-049 | T2003-049 | 33.2 | 34.00 | 2 | 2 | | | | | TUBE ASS'Y | CRES 0.500 OD x 0.035 W | AISI 304 |
| D2003-077 | T2003-077 | N/A | 6.25 | | | | | 1 | 1 | JET | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-101 | T2003-101 | 13.25 | 13.13 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-600/6 |
| D2003-103 | T2003-103 | 12.38 | 12.00 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-600/6 |
| D2003-105 | T2003-105 | 10.75 | 10.60 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-600/6 |
| D2003-107 | T2003-107 | 12.75 | 12.25 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-600/6 |
| D2003-109 | T2003-109 | 8.25 | 8.125 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-600/6 |
| D2003-111 | T2003-111 | 4.75 | 4.625 | | | 2 | 2 | | | TUBE ASS'Y | 6061-T6 0.500 OD x 0.035 W | WWW-T-600/6 |
| D2003-116 | T2003-116 | 4.0 | | | | | | | | HEATSLEEVE | M2650-20 CRINKLE-SOFT | STRATOFLEX |
| D2003-120 | T2003-120 | 4.0 | | | | | | | | HEATSLEEVE | M2650-16 CRINKLE-SOFT | STRATOFLEX |
| D2003-14 | T2003-14 | 4.0 | | | | | | | | HEATSLEEVE | M2650-14 CRINKLE-SOFT | STRATOFLEX |
| D2003-16 | T2003-16 | 4.0 | | | | | | | | HEATSLEEVE | M2650-16 CRINKLE-SOFT | STRATOFLEX |
| D2003-205 | T2003-205 | 9.75 | 9.60 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |
| D2003-207 | T2003-207 | 3.75 | 3.75 | | | | | 2 | 2 | TUBE ASS'Y | 6061-T6 0.375 OD x 0.035 W | WWW-T-700/6 |



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2003 | REV. B SHEET 2 OF 2 |
| DATE 99.06.08 | | TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS | |

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99.06.09 KE

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (VV-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

